

• Work Order ID 110054

110054

Page 1

December-17-13 9:07:07 AM

Item ID: D3512-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 12/30/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/30/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: 11

Date: 12/17

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3512	D
-------	---

100 0.00

100 FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304 . 050 "

1-Cut as per Dwg D3512

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

8 0 Jm14-02-12

110 0.00

110

QC

Memo

Quality Control

8 0 Jm14-02-12

120 0.00

120

QC

Memo

Quality Control

DAS
127
339
14/12/12

8 _____

Work Order ID 110054

110054

Page 2

December-17-13 9:07:07 AM

Item ID: D3512-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Start Date: 12/30/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/30/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Form as per dwg
NC BRAKE

0.00

DAS
30
9-89

130

Brake NC

Brake NC

8

14/02/26

140

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89
14/2/26

8

140

QC

Quality Control

150

Identify as per dwg & Stock Location: WPA 01

0.00

150

Packaging

Packaging

Memo

0.00

DAS
28
9-89

8x

14-2-27

M

Work Order ID 110054

110054

Page 3

December-17-13 9:07:07 AM

Item ID: D3512-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 12/30/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/30/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

MLJ 14-02-28

Quality Control

D 14-02-27

Picklist Print

December-17-13 9:07:07 AM

Page 1

Work Order ID: 110054

Parent Item: D3512-3

Parent Item Name: Spacer

Start Date: 12/30/13

Required Date: 12/30/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM
619/ REV.D DWG DD VERF:JLM

IPP REV:B 13.12.11 ECN13-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	297.8774	0.0943	1		Jm14-02-12	

Location	Loc Qty	Loc Code
MAT019	145.95001	
117188	3.88	
117766	5	
120604	5	
122325	3	
123155	3	
124572	0.00001	
M126647	126.07	
MAT020	151.92742	
120243	0.928	
121626	1.529894	
124029	84.046526	
M126098	65.423	126098

NCR: Yes / No

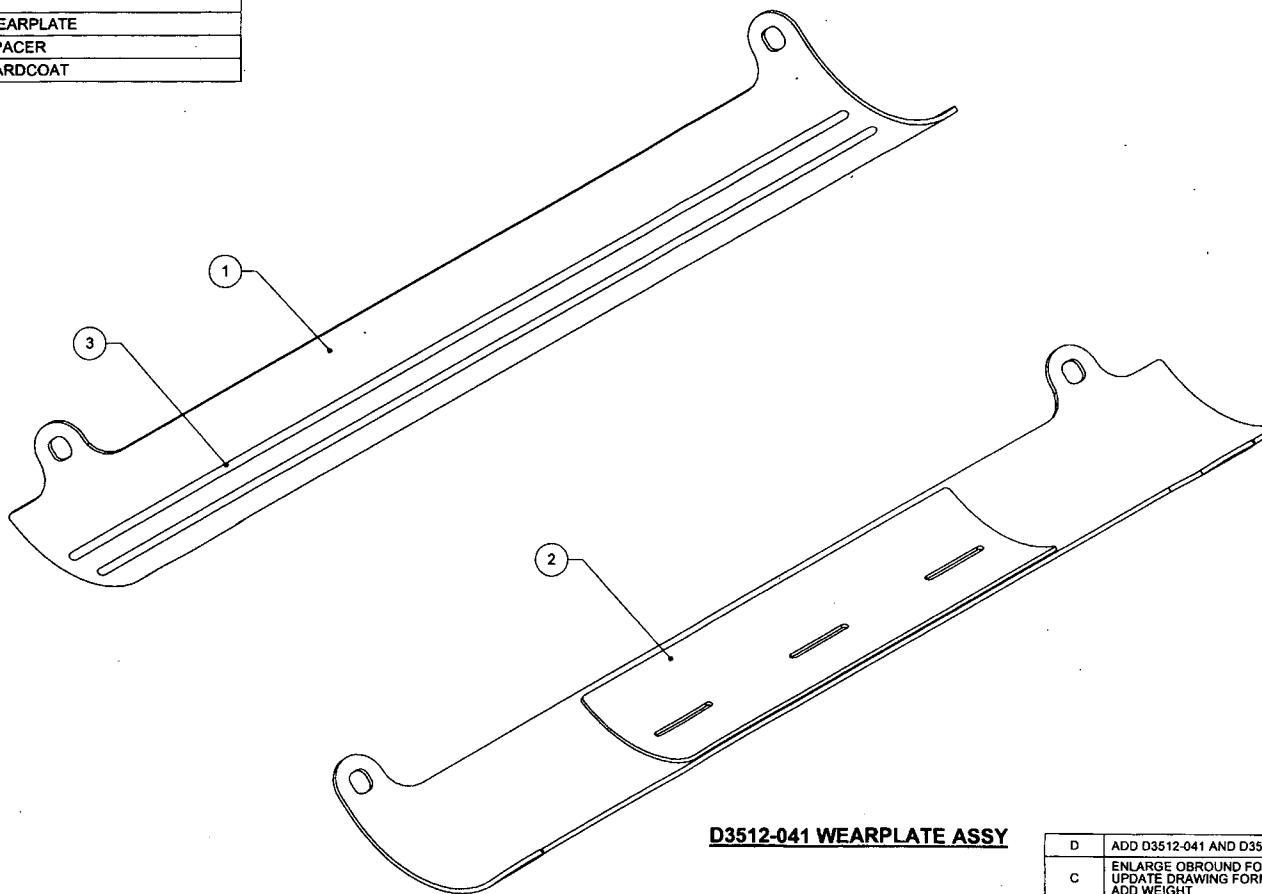
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
	<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced
	<input type="checkbox"/>	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure
	<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld
	<input type="checkbox"/>	Crushed/Crimped	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled
	<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	
	<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
	<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other
	<input type="checkbox"/>	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset				
	<input type="checkbox"/>	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration				
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence					
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions					

ITEM	QTY	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT

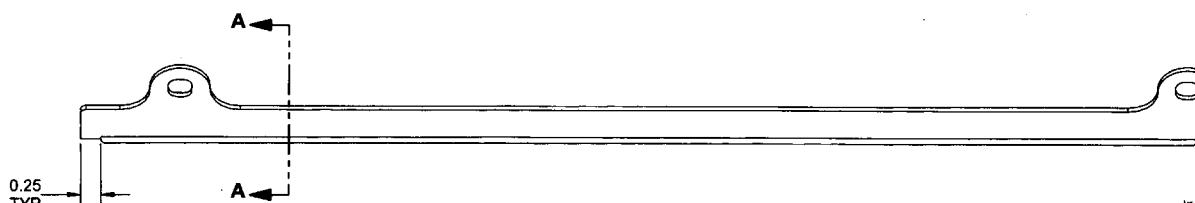
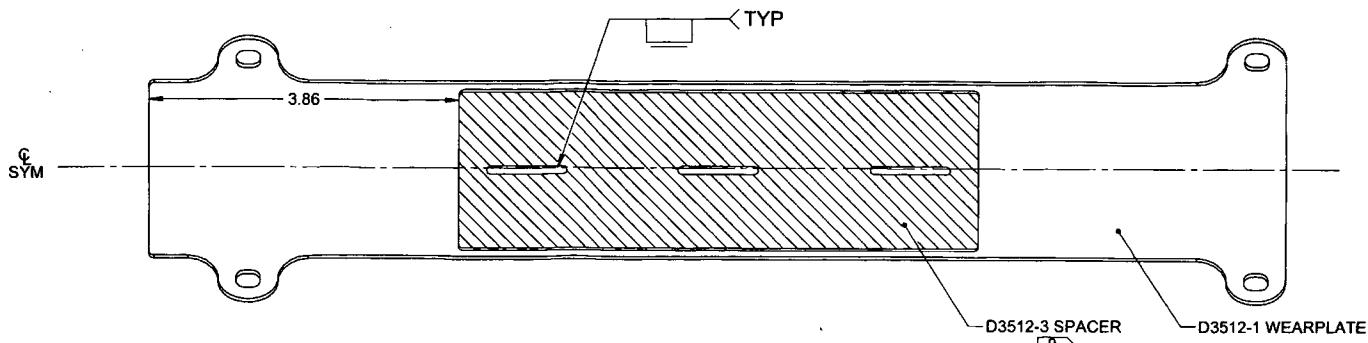


D3512-041 WEARPLATE ASSY

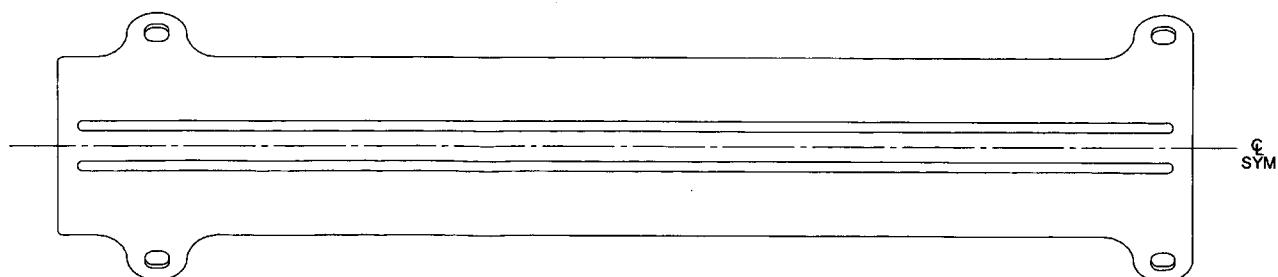
RELEASED
2013-12-10
WP

D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE O-BROUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



SECTION A-A
SCALE 1:1.5



D3512-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

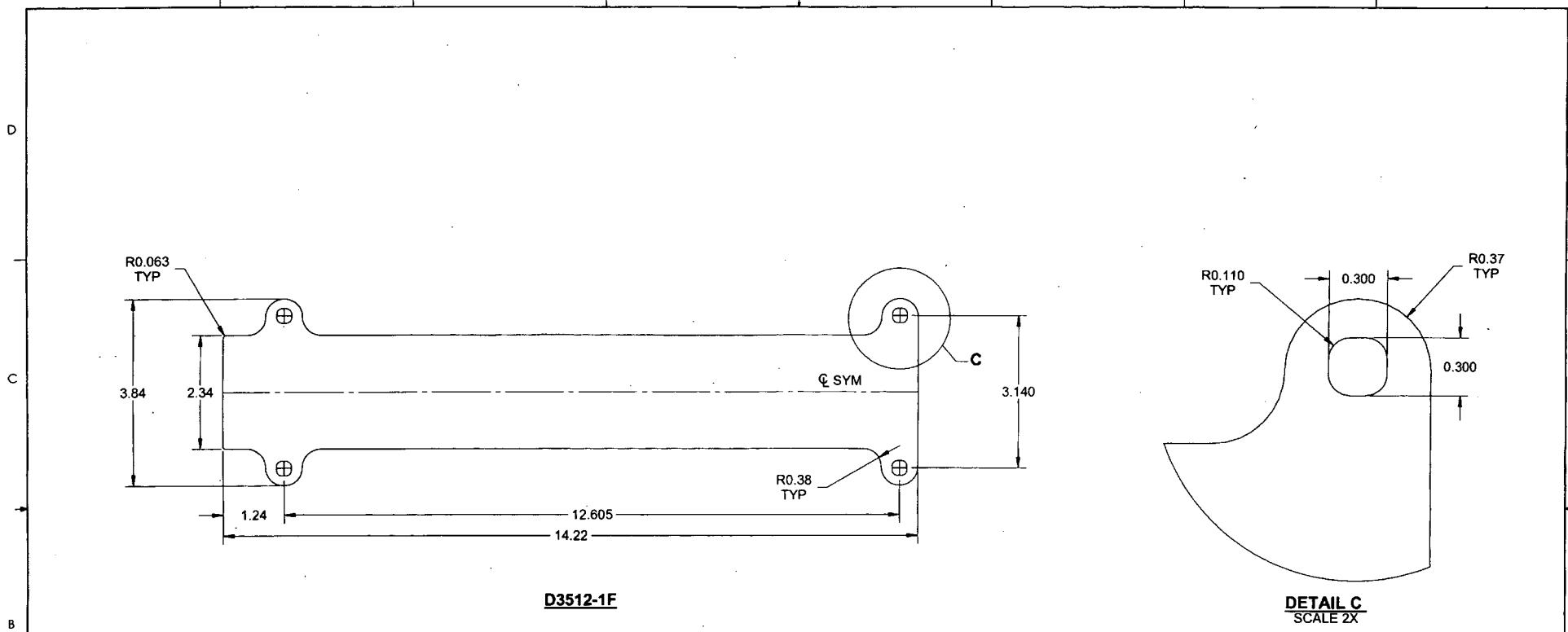
8 7 6 5 4 3 2 1

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MM</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>MM</i>	D3512	SHEET 2 OF 4
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



A B C D 8 7 6 5 4 3 2 1

NOTES:

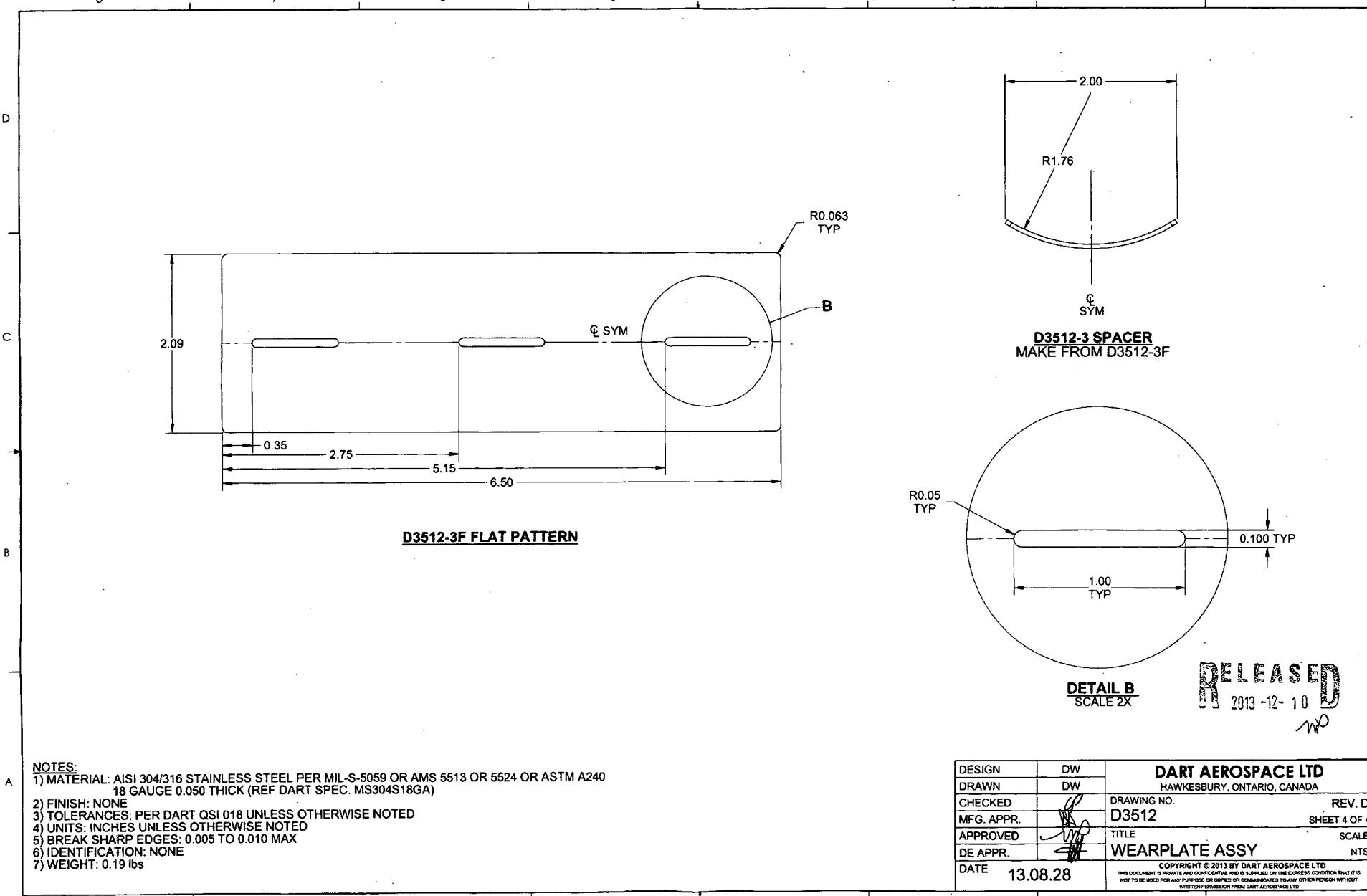
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>UP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>UP</i>	D3512	SHEET 3 OF 4
APPROVED	<i>UP</i>	TITLE	SCALE
DE APPR.	<i>UP</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

RELEASED
2013-12-10
WP

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

DART AEROSPACE LTD	Work Order:	110054
Description: Spacer	Part Number:	03512-3
Inspection Dwg: 03512 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

DAS

Measured by:	Jm	Audited by:	27 9-59	Preliminary Approval:	
Date:	14-02-12	Date:	14-2-12	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.06.15

